

Date: Tuesday, 5/23/2006 8:31:38 AM  
 User: Kim Johnston

## Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 27192  
 Estimate Number : 12338  
 P.O. Number : N/A  
 This Issue : 5/23/2006 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : 26306  
 Written By :  
 Checked & Approved By : JO 06.05.23  
 Comment : Est Rev: A 06.03.21 New Issue JLM

Drawing Name : PLUG

Part Number : D3492045  
 Drawing Number : D3492 REV.A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : N/A  
 Due Date : 6/15/2006

Qty: 80 Um: Each

## Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M6061T6R0500 6061-T6 Round Bar .500"

Comment: Qty.: 0.0656 f(s)/Unit Total : 5.2500 f(s)  
 6061-T6 Round Bar .500"  
 (M6061T6R500)  
 Batch: M19296

HARDINGE CNC LATHE SMALL

2.0 HARDINGE

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA634 & Dwg D3492  
 Dwg Rev: A  
 Folio Rev: A

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK

Comment: SECOND CHECK

5.0 SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1

Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Debur





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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 27192

Part Number: D3492045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HM 06/06/01

(80)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

DL 06/06/01

(80)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06-02-31

(80)

9.0

NAS1611003

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 80.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-003 O-RING

M101724/  
M101907

at per Peter

DL

06/08/24

(59)

DL

06/07/31

(80)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch: M101223 M101223

DL

06/08/24

(21)

DL

06/07/31

(59)

(80)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DL 06-02-31

(1)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP 15

06/08/24

(21)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-08-25

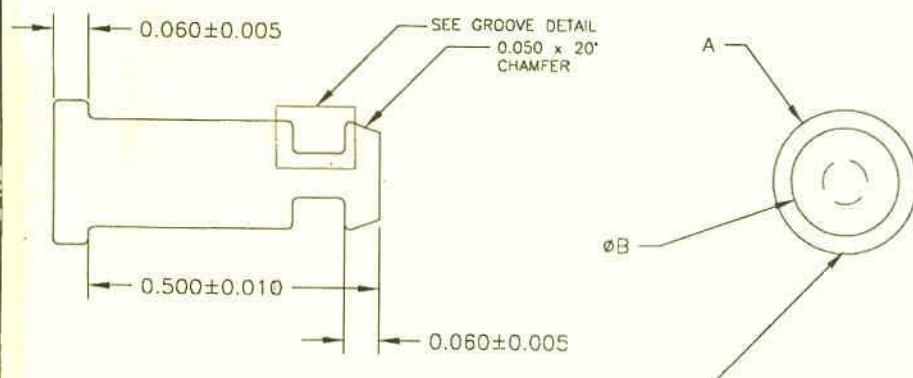
4 06-08-25



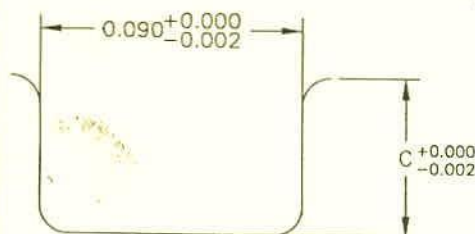








D3492-1/-3/-5 PLUGS IN ACCORDANCE WITH TABLE 1



GROOVE DETAIL

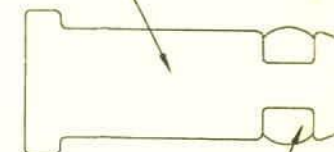
TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.500	0.394	0.055	M6061T6R0.500
D3492-3	0.625	0.582	0.045	M6061T6R0.625
D3492-5	0.375	0.188	0.045	M6061T6R0.250

# D3492-1/-3/-5 PLUG NOTES

- MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.DDD)
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- BREAK ALL SHARP CORNERS 0.010 MAX

D3492-1/-3/-5 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-003/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

## D3492-041/-043/-045 PLUG ASSEMBLY

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST  
(TABLE 2)

Qty -041	Qty -043	Qty -045	Part Number	Description
X			D3492-041	PLUG ASSEMBLY
	X		D3492-043	PLUG ASSEMBLY
		X	D3492-045	PLUG ASSEMBLY
1			D3492-1	PLUG
	1		D3492-3	PLUG
		1	D3492-5	PLUG
		1	NAS1611-003	O-RING
1			NAS1611-010	O-RING
	1		NAS1611-013	O-RING

RELEASED  
06-02-07

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A	06.01.04	NEW ISSUE
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED PH	APPROVED PH	DRAWING NO. D3492
DATE 06.01.04	TITLE PLUG	REV. A SHEET 1 OF 1 SCALE NTS

WORK ORDER  
27192  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
CONTROLLED CO  
ENGINEERING  
RETURN TO  
SHOP COPY

